

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 144115

144115

PRELIMINARY ISSUE

Page 2

Monday, April 04, 2016 10:44:28 AM

Item ID: D5380-3TRN

Accept

N900040100

Setup Start

NS1

Revision ID: PRELIM

Item Name: Support Base

Stop

NS2

Start Date: 4/6/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/15/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	LOCATION: MAT060								16-4-10
140		0.00							
140	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

1 MWS APR 11 2016
POSITIVE RECALL
EFFECTIVE APR 04 2016 AUTH MWS
RELEASED _____ DATE _____
ENG7105APR-HEUSERVICIO

DQA: _____ Date: _____



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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Monday, April 04, 2016 10:44:35 AM

PRELIMINARY ISSUE Page 1

Work Order ID: 144115

144115

Parent Item: D5380-3TRN

D5380-3TRN

Parent Item Name: Support Base

Start Date: 4/6/2016

Required Date: 4/15/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev.A New issue JFS 16/02/03 Verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6104-007		Manufactured	No			100	Each	20.0000	1	2			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D6104-007******

Round Billet, 17-4

LocationLoc QtyLoc Code

MAT043

20

142009

8

142433

12

DAS

45

9-89

2016-4-7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

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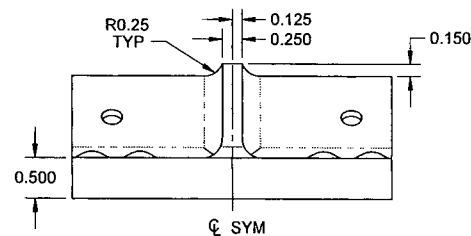
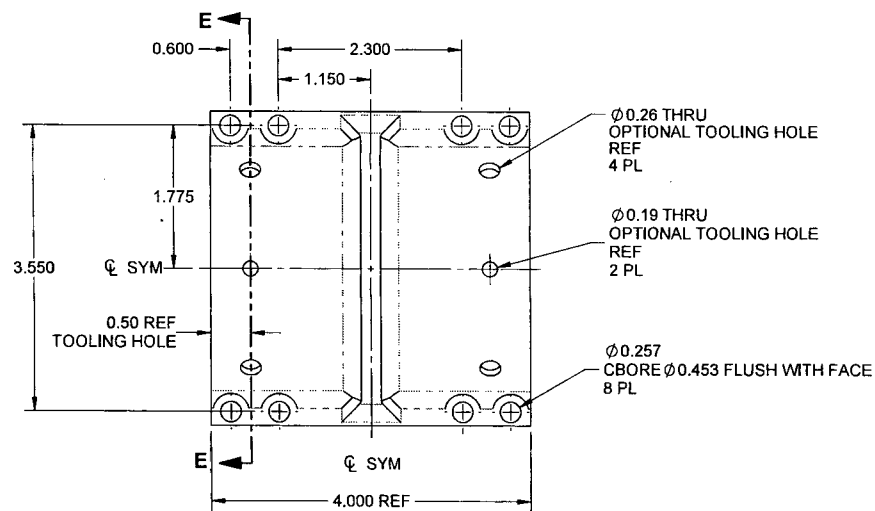
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

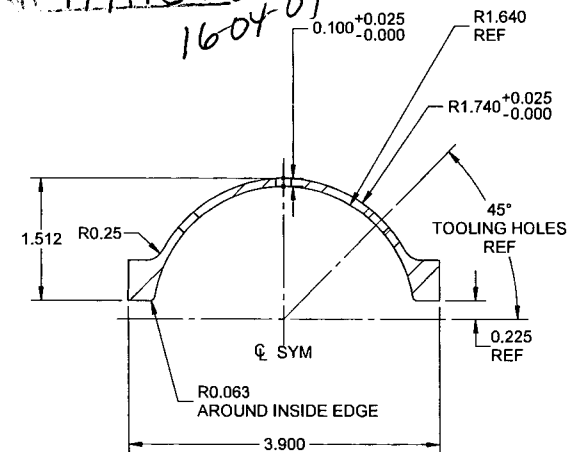
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

PRELIMINARY ISSUE



D5380-3 SUPPORT BASE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 144115 MLJ
160404



SECTION E-E
SCALE 1X

- NOTES:
- 1) MATERIAL: MAKE FROM D5380-3TRN
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
 - 7) WEIGHT: 0.89 lbs
 - 8) PROFILE ALL NON DIMENSIONED FEATURES PER CAD FILE "D5380-3-REVA.STP"

PRELIMINARY ISSUE

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. A9
MFG. APPR.	JFS	D5380	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT	NTS
DATE	16.01.05	COPYRIGHT © 2016 BY DART AEROSPACE LTD	
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

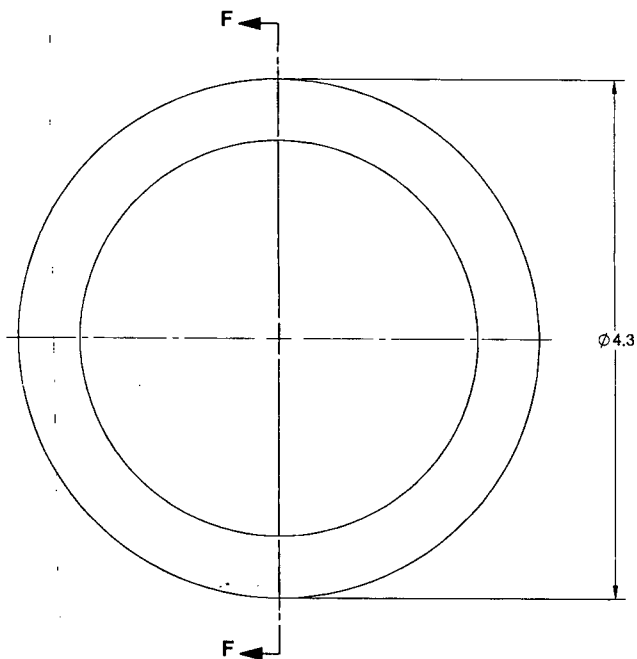
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Work Order update only ☐

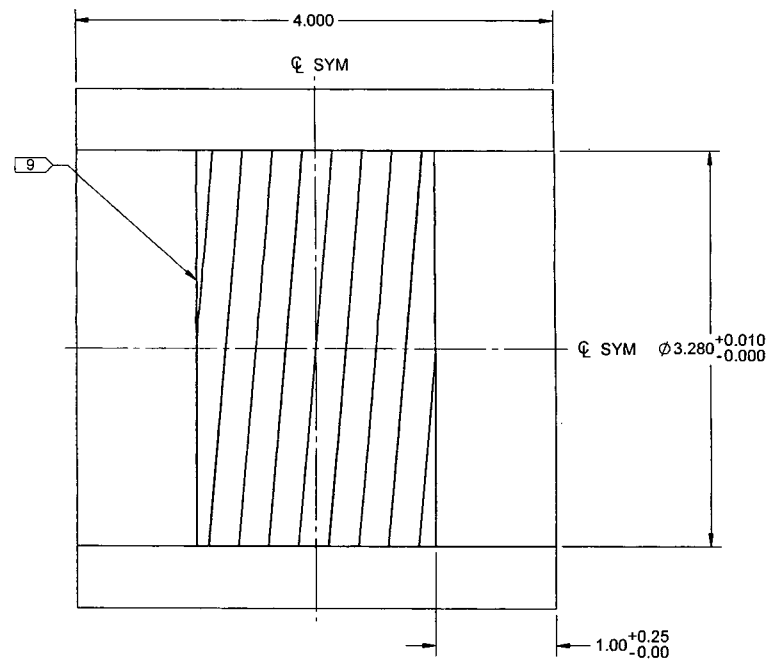
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				
Misidentified ☐	Past Due ☐					

PRELIMINARY ISSUE



D5380-3 TRN



SECTION F-F
SCALE 1X

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 ROUND BAR PER AMS 5643 / ASTM A564 H900 OR H925 CONDITION, MIN UTS = 170 KSI (38 HRC) REF DART SPEC. M17-4-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO AND P/N WITH 0.125 HIGH LETTERING AND 0.010-0.020 DEEP PER DART QSI 044 6.3
- 7) WEIGHT: 7.02 lbs
- 8) PROFILE ALL NON DIMENSIONED FEATURES PER CAD FILE "D5380-3TRN-REVA.STP"
- 9) SURFACE IS TO BE THREADED USING R0.032 TOOLING AT A DEPTH OF 0.032 $\frac{+0.002}{-0.016}$ WITH A PITCH OF 0.125 $\frac{+0.010}{-0.010}$

PRELIMINARY ISSUE

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. A9
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OTHER : ☐					

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31480

Purchase Order Date 2/24/2016

PO Print Date 2/24/2016

Page Number 2 of 3

Order From :

VU-MET002

Ship To : DART AEROSPACE LTD

METAUX CASTLE
P.O. BOX 4090 STN A
TORONTO, ONTARIO M5W OE9
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

USD

Destination-Collect

Ship To Contact

Ship To Phone

Ship Via:

Yours ppd

Ship Acct:

Line Total: \$724.00

3	D6104-007P	17-4 SS Roundbar 4.50"Od	3/11/2016	10.00	\$68.53	\$685.30
			Yes	Each		
			3/11/2016			

AS PER DWG D6104 REV. B
B142009
MATERIAL: 17-4 PH AS PER AMS 4643 OR AISI 630
SIZE: 4.50" X 5.10" LONG

Line Total: \$685.30

4	M2024T3A0.750X0.750X.040	2024-T3 ANGLE .750' X .750 X .040" WALL	3/11/2016	12.00	\$35.86	\$430.32
			Yes	f		
			3/11/2016			

MATERIAL: 2024-T3/T3510/T3511 ALUMINUM ANGLE
AS PER AMS-QQ-A-200/3 PR AMS 4152/4164/4165
MATERIAL # 60-34384-23-144

Line Total: \$430.32

Note:

2/24/2016

**Castle Metals®**

A. M. Castle & Co.

**PACKING SLIP/
CERTIFICATE OF CONFORMANCE**

Page 1 of 2

Shipment No:2900534

Ship From: A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 01-MAR-16	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier MANITOULIN		BOL No 2900534-2	

Shipment Details			Final Destination Branch - TOR				
Order No 4265754	Line No 3	Item No 14998 MO	Description 4.5000.RD.17CR-4NI.STAINLESS.RT.SOL TR.COND A.132.0000-156.0000 CUT TO 5.1 IN (+ .1250/- .0000 IN) - BAND SAW CUTTING SPECIFICATIONS: AMS 5643				
Purchase Order No 31480	Part Number YOUR ITEM NUMBER: D6104-007		Ordered Qty 5.00 PCS	Invoice Qty 5.00 PCS			
Details	ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #'S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS 8816-03-3						
Delivery No. 120355044	Mill NORTH AMERICAN STAINLESS	Heat Number 	Mech Id 5	PCS	Width (IN)	Length (IN)	Shipped Qty(LBS) 118.2132

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned.

These commodities, technology or software were exported from the United States in accordance with the Export Administration Regulations. Diversion contrary to US law prohibited.

Date Printed: 01-MAR-2016 04:45:14 PM



**NORTH AMERICAN
STAINLESS**

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 986856 12 Mail To:
A.M. CASTLE AND COMPANY
1420 KENNEDY ROAD-SUITE 220
OAK BROOK IL 60523

Ship To:
A.M. CASTLE AND COMPANY
3400 NORTH WOLF ROAD
FRANKLIN PARK IL 60131

Date: 9/16/2014 Page: 1 Of 1
Steel: 630(17-4)
Finish: HOT FINISH
Dia/Thk: 4.5000 in
Log Length:
Length: 144.00 in
Corrosion:

Customer: 0032 001
NAS Order: LP 23209 1
Your Order: 294342

Item Code: 14998

PRODUCT DESCRIPTION:

AMS 2303E, AMS 5643E
Round Bar, Hot Rolled, Annealed, Rough Turned
UNS S17400; EN 10204 3.1, ASTM A484/11, MACRO OK, AMS 5643T
ASTM A564/10, AMS 2303, ASME SA564-07, ASTM F899/11 (CHEM ONLY)
SOL. ANNEALED @ 1900F MIN FOR 1 HR MIN. and air cooled to RT
H900 MECH. PROPERTIES ARE CAPABILITY ONLY*

REMARKS:

COMPLIES W/REQUIREMENTS OF DPAR 252.225-7009 EU DIRECTIVE
2011/65/EU. RoHS. EAF+AOD+CC. NO WELD REPAIR. MELTED AND MFG
IN USA FREE FROM MERCURY AND LOW MELTING ALLOY CONTAMINATION

DAS

14

9-09

9/16/03/04

Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight
BG61764	1980								

CHEMICAL ANALYSIS

CM(Country of Melt) ES(Spain) US(United States) ZA(South Africa) JP(Japan)

Chemical Analysis per ASTM A751/08

Heat	Supplier #	CM	C %	CB %	CO %	CR %	CU %	FE %	MO %	N %	NI %	P %
N5T6		US	.016	.286	.10	15.14	3.07	.77	.14	.036	4.43	.025
			S %	SI %	TA %	TI %						
			.0225	.39	.0050	.0020						

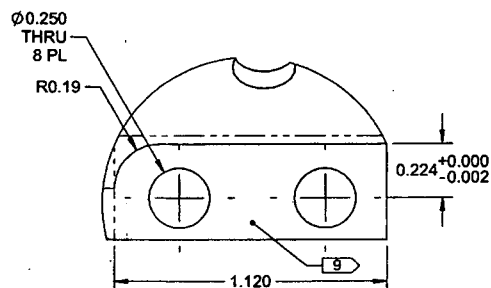
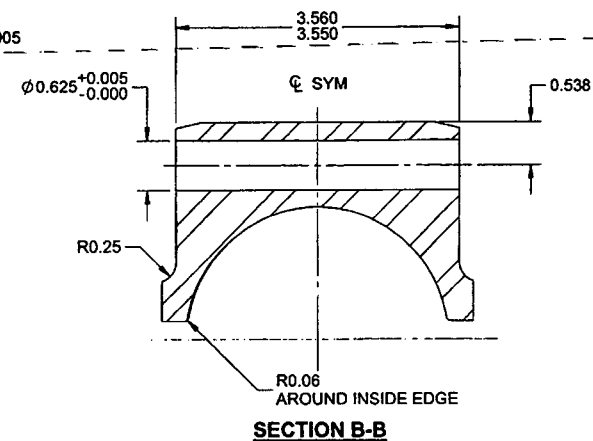
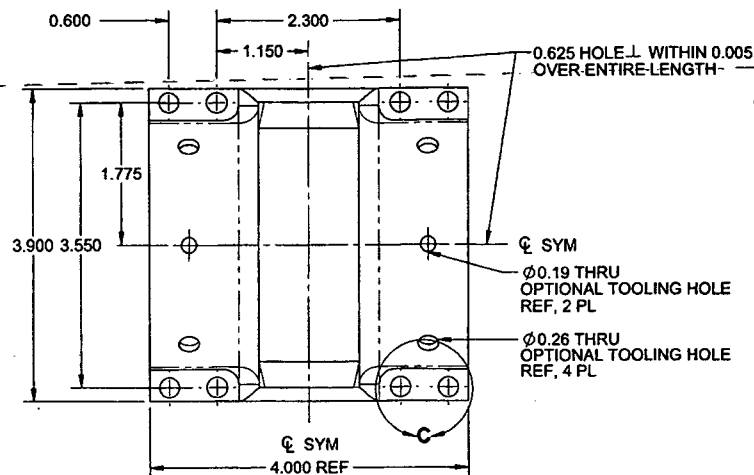
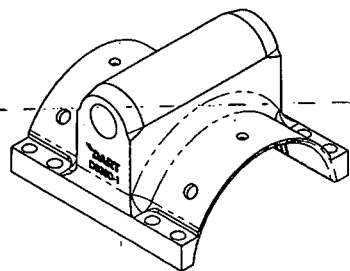
MECHANICAL PROPERTIES

	1 d	HB	Grain	Ferrite	TS-900CAP	YS-900CAP	EL-900CAP	RA-900CAP	RC-900CAP	FREQ.	SEV.
	o 1	No.	No.	%	KSI	KSI	% 4D	%	No.	No.	No.
BG61764	R L	321.0	7.0	.80	196.11	173.92	13.38	43.95	41.5	.17	.10

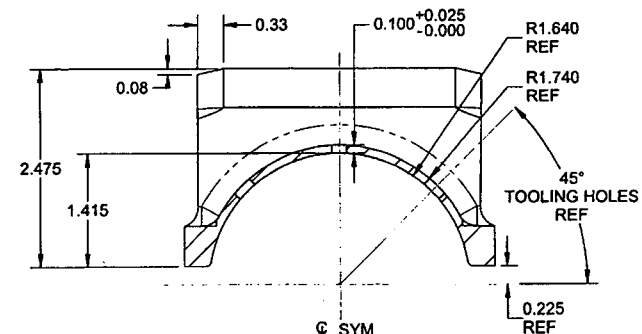
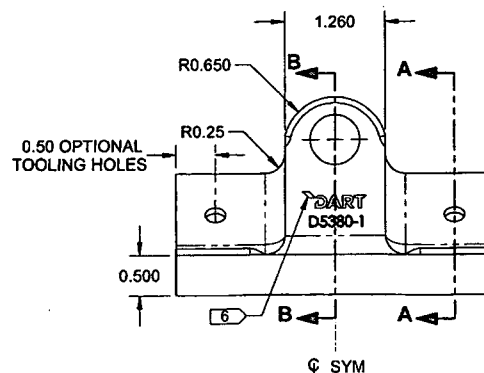
NAS hereby certifies that the analysis on this certification is correct. Based upon the results and the accuracy of the test methods used, the material meets the specifications stated. These results relate only to the items tested and this report cannot be reproduced, except in its entirety, without the written approval of NAS

Technical
Dept. Mgr.

ABHJEET BHAVE
ABHJEET BHAVE



DETAIL C
SCALE 2X
4 PL



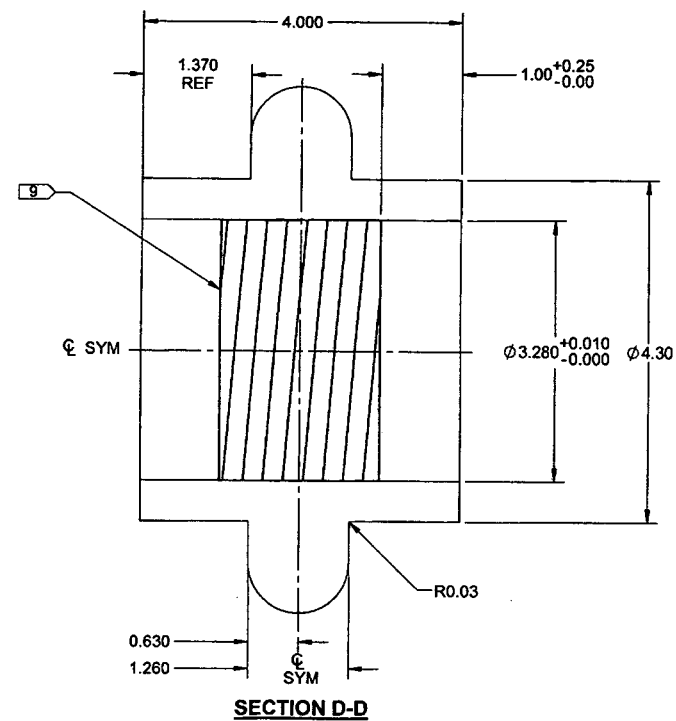
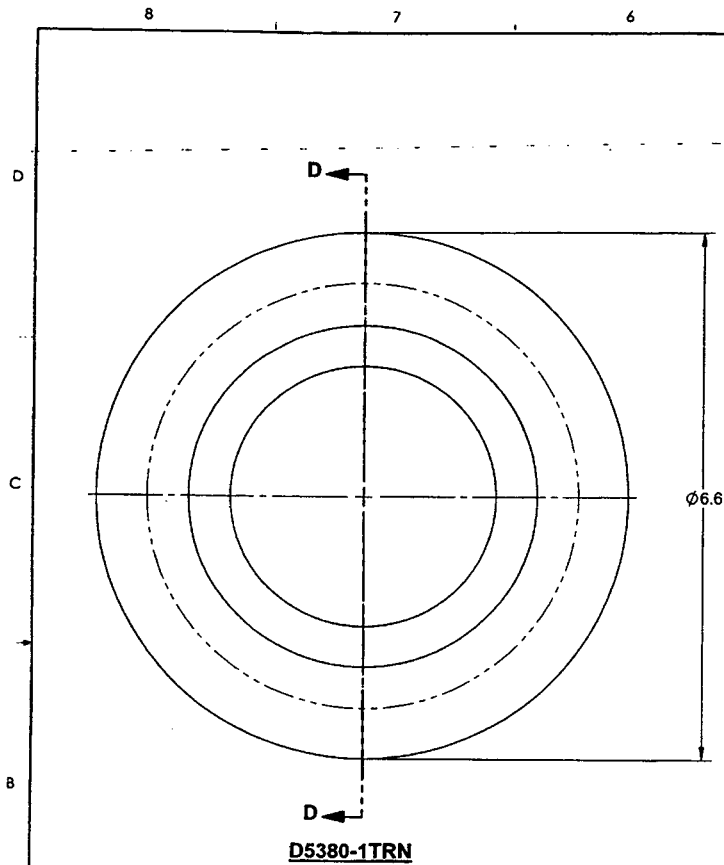
- NOTES:**
- 1) MATERIAL: MAKE FROM D5380-1TRN
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART LOGO AND P/N WITH 0.125 HIGH LETTERING AND 0.005-0.010 DEEP PER DART QSI 044 6.3
 - 7) WEIGHT: 2.09 lbs
 - 8) PROFILE ALL NON DIMENSIONED FEATURES PER CAD FILE "D5380-1.REVA.STP"
 - 9) REMOVE MATERIAL FLUSH TO FACE

RELEASED
2016-05-19
EAL 16-515

APPROVED

A NEW ISSUE		ML	16.01.05
REV.	DESCRIPTION	BY	DATE
DESIGN	ML		
DRAWN	ML		
CHECKED	AJS		
MFG. APPR.	RQ		
APPROVED	DW		
DE APPR.	DS		
DATE	16.01.05		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D5380	REV. A
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NOTES:

1) MATERIAL: 17-4 PH/S17400/TYP 630 ROUND BAR PER AMS 5643 / ASTM A564
H900 OR H925 CONDITION, MIN UTS = 170 KSI (38 HRC)
REF DART SPEC. M17-4-R

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER DART QSI 044

7) WEIGHT: 13.21 lbs

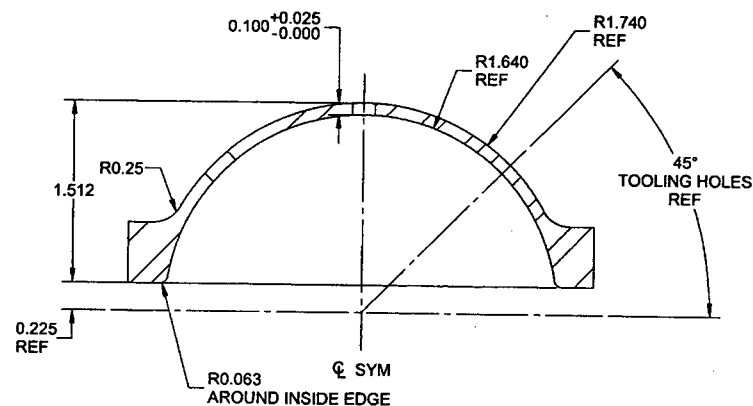
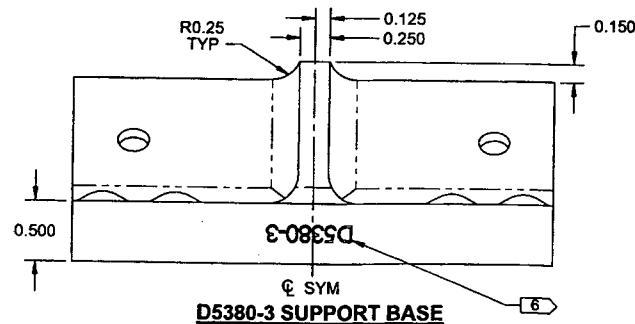
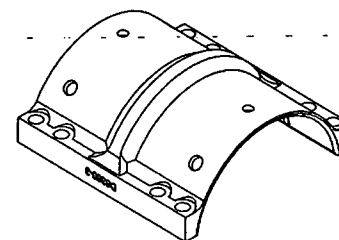
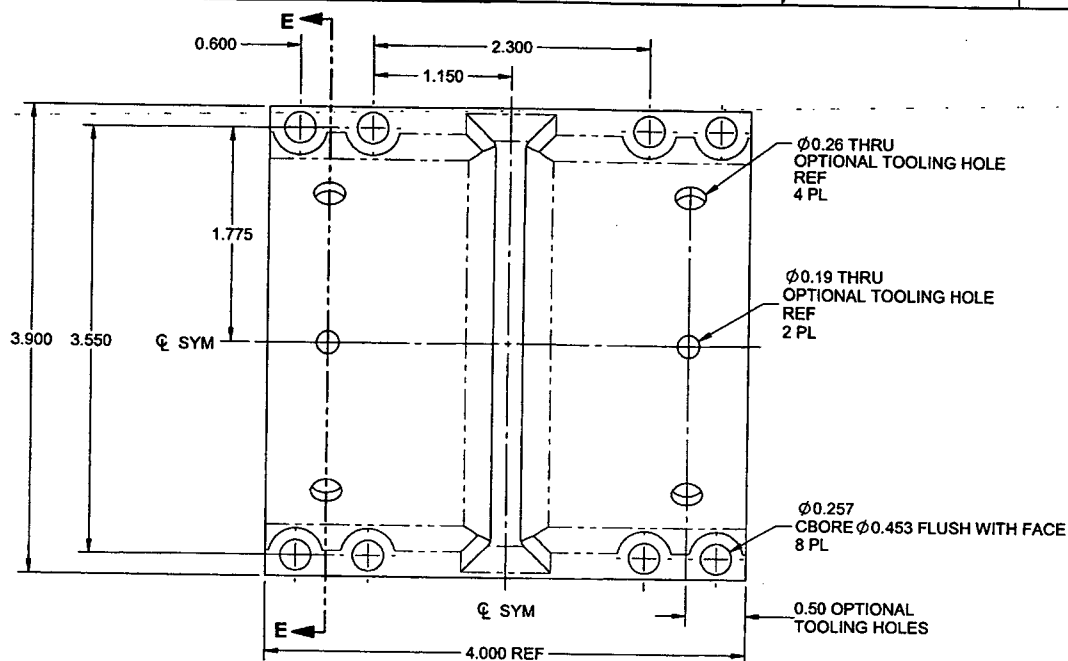
8) PROFILE ALL NON DIMENSIONED FEATURES PER CAD FILE "D5380-1TRN-REVA.STP"

9) SURFACE IS TO BE THREADED USING R0.032 TOOLING AT A DEPTH OF 0.032^{+0.002}/_{-0.010} WITH A PITCH OF 0.125^{+0.010}/_{-0.010}

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2016-05-19

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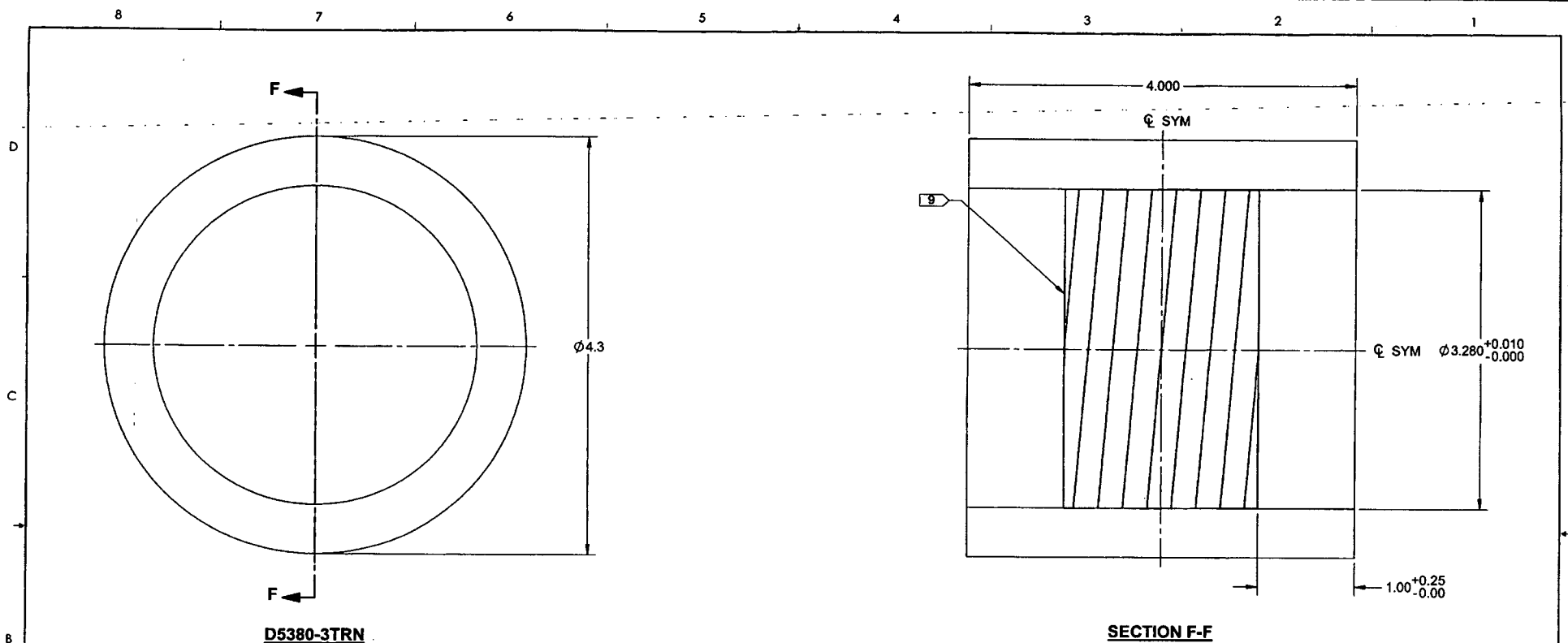
SECTION E-E

- NOTES:
- 1) MATERIAL: MAKE FROM D5380-3TRN
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART P/N WITH 0.125 HIGH LETTERING AND 0.005-0.010 DEEP PER DART QSI 044 6.3
 - 7) WEIGHT: 0.89 lbs
 - 8) PROFILE ALL NON DIMENSIONED FEATURES PER CAD FILE "D5380-3-REVA.STP"

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NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYP 630 ROUND BAR PER AMS 5643 / ASTM A564 H900 OR H925 CONDITION, MIN UTS = 170 KSI (38 HRC) REF DART SPEC. M17-4-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: 7.02 lbs
- 8) PROFILE ALL NON DIMENSIONED FEATURES PER CAD FILE "D5380-3TRN-REVA.STP"
- 9) SURFACE IS TO BE THREADED USING R0.032 TOOLING AT A DEPTH OF 0.032 ± 0.002 WITH A PITCH OF 0.125 ± 0.010

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2016-05-19

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